

Date: Wednesday, 12/13/2006 2:41:31 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP LEG  
 Job Number : 29922B  
 Estimate Number : 10353  
 P.O. Number : *NA*  
 This Issue : 12/13/2006 S.O. No. : *N/A*  
 Prsht Rev. : NC  
 First Issue : *NA* Type : SMALL /MED FAB  
 Previous Run : 29846  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]*  
 Comment : Est Rev:A New Issue 05-11-07 JLM  
 Est Rev:B Now 6061-T6 06-06-23 JLM

Part Number : D2278  
 Drawing Number : D2278 REV E  
 Project Number : N/A  
 Drawing Revision : E  
 Material : *N/A*  
 Due Date : 1/5/2007 Qty: 40 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 1.0306 sf(s)/Unit Total : 41.2230 sf(s)  
 Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick *11.3366*  
 (M6061T62S.080)  
 Identify as D2278 *29.8874* *M103713*  
 Batch: *M103434* *m1070307*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D2278  
 Dwg Rev: *E*  
 Prog Rev: *E*

2-Deburr if necessary

*ml*

*07/03/07*

*07/03/17*

*(40)*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/03/04*

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*07/03/08*

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

*07-03-20*

Dart Aerospace Ltd.  
 W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/00  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/13/2006 2:41:32 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 29922B

Part Number: D2278

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Handwritten: 7/3/20 40*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*Handwritten: 7/3/20*

*Handwritten: SP H63/20 40*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



*Handwritten: 40*

Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten: 07/03/20*

Job Completion



*Handwritten: U 07-03-20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

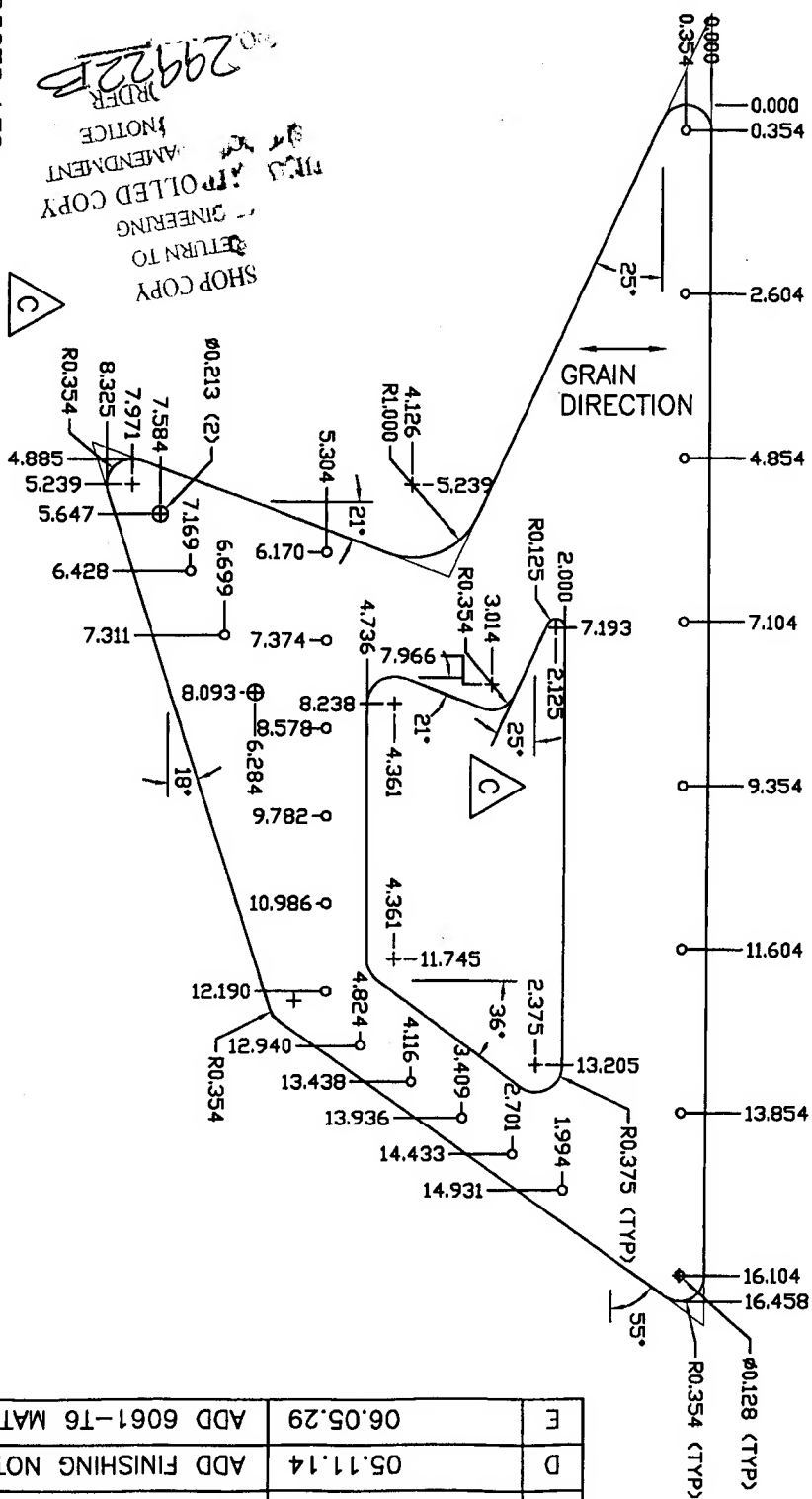
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

RELEASED  
06.06.20



SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
NOTICE  
29922B

**D22278 LEG**

- 1) MATERIAL:  
6061-T6 ALUMINUM SHEET (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR  
5052-H32 ALUMINUM SHEET (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)  
ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 2) FINISH:
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	CB	APPROVED	[Signature]	DRAWING NO.	D22278	REV. E	SHEET 1 OF 1	SCALE	1:2.5
DATE											
06.05.29											
TIME											
LEG											
CHANGED RADIUS TO 0.354											
D											
05.11.14											
ADD FINISHING NOTE											
E											
06.05.29											
ADD 6061-T6 MATERIAL											

